Date

Friday, 06/07/2007 1:36:25 PM

User: Linda Lacelle **Process Sheet** : CU-DAR001 Dart Helicopters Services **Drawing Name** : LITTER DECKPLATE 350 Customer Job Number : 33262 **Estimate Number** : 10357 P.O. Number 414: **Part Number** : D2344 S.O. No. : NIA : 06/07/2007 : D2344 REV F **Drawing Number** This Issue Prsht Rev. **Project Number** : N/A : MACHINED PARTS Type First Issue **Drawing Revision** : NIA : 33262 **Previous Run** Material **Due Date** : 10/07/2007 Each Qty: 4 Um: Written By Checked & Approved By Comment : Est Rev:D 00.06.26 Removed P/O for powder coat EC 07-07-04 Asper Rev F JLM Est Rev:E **Additional Product** Job Number: Seq. #: **Machine Or Operation: Description:** M2024T3S063 1.0 2024-T3 .063 sheet Comment: Qty.: 0.7823 sf(s)/Unit Total: 3.1290 sf(s)Material: 2024-T3 QQ-A-250/5) .063 Batch 1104921 FLOW WATER JET 2.0 Comment: FI OW WATER JET 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0 SECOND CHECK Comment: SECOND CHECK 5.0 SMALL FAB SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL/MED FAB

1-Deburr sharp edges

2-Countersink holes per Dwg D2344

07.08.07

Date:

Friday, 06/07/2007 1:36:25 PM

User:

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: LITTER DECKPLATE 350** 

Job Number: 33262

Part Number: D2344

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



7.0

HAND FINISHING RESOURCE #1





Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONV



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION



PACKAGING 1

PACKAGING RESOURCE



10.0

11.0

Comment: Identify and Stock

Location:



Comment: FINAL INSPECTION/W/O RELEASE





Job Completion



N 7908-24

Date:

Friday, 6/29/2007 11:17:54 AM

Kim Johnston User: **Process Sheet** : LITTER DECKPLATE 350 **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 33262 **Estimate Number** : 10357 **Part Number** : D2344 P.O. Number : D2344 UNDER REVIEW-**Drawing Number** : 6/29/2007 S.O. No. : This Issue : N/A : NC Project Number Prsht Rev. First Issue : // Type : MACHINED PARTS **Drawing Revision** ドアト : 31918 Material Previous Run : 7/10/2007 Each **Due Date** Qty: 4 Um: Written By Checked & Approved By Comment : Est Rev:D 00.06.26 Removed P/O for powder coat EC **Additional Product** Job Number: Machine Or Operation: Description: Seq. #: 1.0 M2024T3S063 2024-T3 .063 sheet Comment: Qty.: 0.7823 sf(s)/Unit Total: 3.1290 sf(s) Material: 2024-T3 QQ-A-250/5) .063 Batch 20 WATER JET FLOW WATER JET Comment: FLOW WATER JET 30 QC2 INSPECT PARTS AS Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK SMALL & MEDIUM FAB RESOURCE 1 5.0 Comment: SMALL/MED FAB 1-Deburr sharp edges 2-Countersink holes per Dwg D2344 6.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP

Page 1

## **Dart Aerospace Ltd**

W/O:		WORK ORDER C	HANGES				18 18
DATE	STEP	PROCEDURE CHANGE	Е	By Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	):	PAR #: Fault Category:	NCR:	Yes No D	QA:	Date:	

QA: N/C Closed: \_\_\_\_ Date: \_\_

NCR:		•	WORK ORD	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section E	Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
						1		
		·						
•								

NOTE: Date & initial all entries

Friday, 6/29/2007 11:17:54 AM Date: User: Kim Johnston **Process Sheet Drawing Name: LITTER DECKPLATE 350** Customer: CU-DAR001 Dart Helicopters Services Job Number: 33262 Part Number: D2344 Job Number: Seq. #: Description: Machine Or Operation: HAND FINISHING1 7.0 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 POWDER COATING 8.0 Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 Comment: INSPECT POWDER COAT/CHEMICAL ONVERSION PACKAGING 1 PACKAGING RESOURCE #1 10.0 Comment: Identify and Stock Location: 11.0 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
				•					
Part No	):	PAR #: Fault Category:	NCR: Yes	No DQ	<b>\</b> :	Date:			

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_

NCR:			WORK ORDI	ER NON-CONFORMAN	CE (NCR)			
778-17-18-17		Description of NC	Description of NC Corrective Action Section B				Annroval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
						-		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Litter Deck Plate Kit (350)	Part Number:	D2344
Inspection Dwg: D2344 Rev: E		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article **Prototype** 

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments
	0.991 7	+/-0.005						
	6.223	+/-0.010	6,222	1		Vern		
	5.598	+/-0.010	5,598	V		Vern		
	4.869	+/-0.010	4.868	1		Vera		
	3.889	+/-0.010	3.845		,	Vern		
	3.096	+/-0.010	3.101			Vern.		
	2.891	+/-0.010	2.899	V		Vern		
1	16.973	+/-0.010	16.963	/		M-T/verz		
	0.966	+/-0.005						
	0.450	+/-0.010	0.457		,	Vern		
	4.423	+/-0.010	4,423	J		Vern		
	4.723	+/-0.010	4,722	1		Vern		
	1.202	+/-0.010	1.204			Vern		
	5.869	+/-0.010	5.870	V	_	Vern		
	4.654	+/-0.010	4.650			Vern		
	Ø0.656	+0.005/-0.000	\$0.657			Vern		
	1.888	+/-0.010	11,791			Vern		
	2.285	+/-0.010	2.290			Vern	•	
	2.683	+/-0.010	2.685	1		Vern	***	
1	Ø0.171	+0.005/-0.000	00,173			Vern		
[[]]	€ 0.750 ₹	<b>1/A</b> +/-0.005						
	3.491	+/-0.010	3,494			Vern		
<i>a a</i>	Ø0.191	+0.005/-0.000	\$0.192	/		Vern		
[[w]]	₩ 0.796 ₹	1/4+/-0.005						
1	3.123	+/-0.010	3,127			Vern		
159	1527-3	V/A- +/-0.010						
	1.975	+/-0.010	1.980		,	Jern		
6/1	1.128	t.88/	100.128	10		Vern		
	Measured by:	SAN	Audited by:	رم		Prototype Ap	proval:	N/A
	D-4	171-103	D-4	-/	~/		Data	NI/A

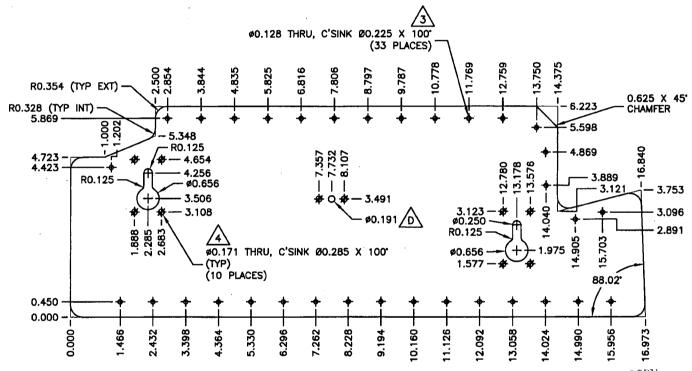
07/08/02 Date: Date: Date: N/A

Rev	Date	Change		Revised by	Approxe	ed
Α	04.06.25	New Issue	P/O D350-616-015	KJ/JLM	\JJ!	





DESIG KE	N  -	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	(ED)	APPROVED	DRAWING NO. REV. F D2344 SHEET 1 OF 1
DATE	,		TITLE SCALE
07.0	6.07		LITTER DECK PLATE, 350 1:3
Α		95.01.14	NEW ISSUE
В		95.02.09	MOVED KEY HOLES
D		95.03.06	0.191 WAS 0.197
E		98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)
F		07.06.07	C'SINK Ø0.285 WAS Ø0.308



SHOP COPY RETURN TO

ENGINEERING

D2344 LITTER DECK PLATE.

UNCONTROLLED COPY 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063-0.071 THICK PER QQ-A-250/SUBJECT TO AMENDMENT (REF. DART SPEC. M2024T3S)

2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3 WITHOUT NOTICE 3) COUNTERSINK HOLES MARKED \$ TO \$0.225 \times 100'
4) COUNTERSINK HOLES MARKED \$ TO \$0.285 \times 100'

E) PREAL ALL CHARD STATE OF \$ 0.285 \times 100'

5) BREAK ALL SHARP EDGES 0.005 TO 0.010

6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

8) IDENTIFY WITH DART P/N "D2344" USING WHITE PAINT MARKER

RELEASED

NO. \_\_\_

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